

Date: Monday, 6/2/2008 8:40:00 AM
 User: David Guval

Process Sheet

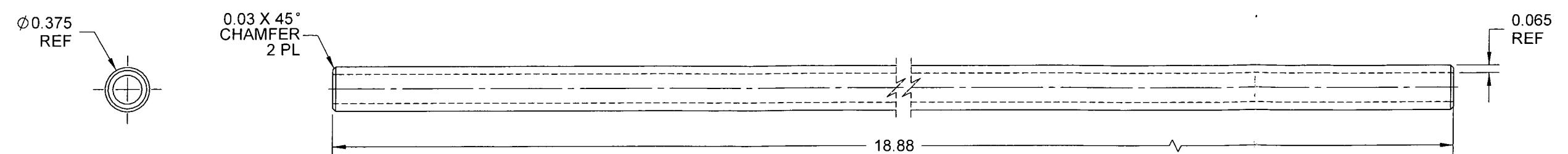
Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LATCH GUIDE	
Job Number	: 05020		Part Number	: D35895	
Estimate Number	: 13349		Drawing Number	: D3589 PROTO	
P.O. Number	:		Project Number	: VR0004	
This Issue	: 6/2/2008	S.O. No. :	Drawing Revision	: PROTO 08.05.27	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : R&D MACHINED PARTS	Due Date	: 6/9/2008	Qty: 2 Um: Each
Previous Run	:				
Written By	: <u>08/05/08</u>				
Checked & Approved By	:				
Comment	: Est Rev:A 08-05-29 new issue DD verified by:EC				

Additional Product

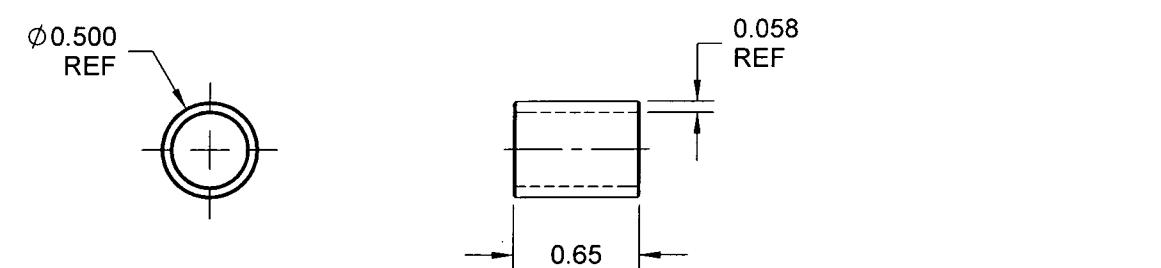
PROTOTYPE

Job Number:			FOR ENGINEERING USE ONLY		
Seq. #:	Machine Or Operation:	Description :			
1.0	M4130NT0500W049	4130 Tube .500 OD x.049W 			
Comment: Qty.: 0.2625 f(s)/Unit Total : 0.5250 f(s) 4130 Tube .500 OD x.049W batch: <u>M106651</u> <u>08/06/08 (2)</u>					
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 			
Comment: 1-TURN AS PER FOLIO FA755 & DWG D3589 FOLIO REV: <u>1/1</u> <u>08.06.02</u> DWG REV: <u>M14</u> <u>08.06.02</u> 2-DEBURR AS REQUIRED <u>08/06/08 (2)</u>					
3.0	QC5	INSPECT WORK TO CURRENT STEP ENGINEERING APPROVAL  <u>08.06.02 (2)</u>			
Comment: INSPECT WORK TO CURRENT STEP					
4.0	PACKAGING 1	PACKAGING RESOURCE #1  FOR ENGINEERING USE ONLY 			
Comment: PACKAGING RESOURCE #1 Identify and Stock: Location: <u>08/06/08 (2)</u>					
5.0	QC21	FINAL INSPECTION/W/O RELEASE 			
Comment: FINAL INSPECTION/W/O RELEASE <u>08.06.05 Prototype</u>					
Job Completion  <u>charge to 6/10 #00224</u>					

8 7 6 5 4 3 2 1

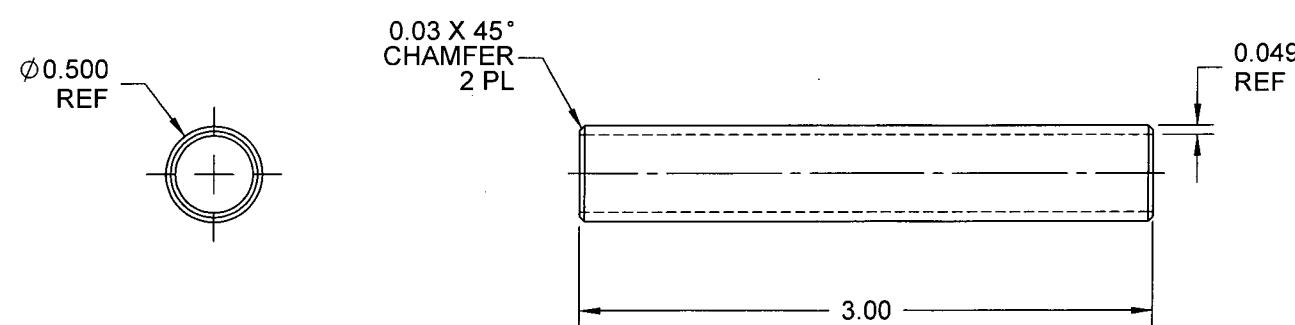


D3589-1 ARM



D3589-3 ARM GUIDE

~~FA 754~~
FA 754



D3589-5 LATCH GUIDE

FA 755

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.05.29

D3589-1/3/5 NOTES:

1) MATERIAL:

D3589-1: AISI 4130 STEEL TUBING 0.375 O.D. 0.065 WALL (REF. DART SPEC M4130N-T0375W065)
D3589-3: AISI 4130 STEEL TUBING 0.500 O.D. 0.058 WALL (REF. DART SPEC M4130N-T0500W058)
D3589-5: AISI 4130 STEEL TUBING 0.500 O.D. 0.049 WALL (REF. DART SPEC M4130N-T0500W049)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT:

- D3589-1 = 0.38 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs

DESIGN	<i>[Handwritten]</i>	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3589
DE APPR.		SHEET 4 OF 7
DATE		TITLE
	08.05.29	SCALE
		NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS		
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		
WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

8 7 6 5 4 3 2 1

PROH Acier Campi

CERTIFICAT D'ESAICUSTOMER ORDER NUMBER
NUMÉRO DE COMMANDE DU CLIENT36330-33
PART NUMBER/NUMÉRO DE PIÈCESOLD TO: ACIER CAMPI INC.
VENDU À: 935 BLVD DU HAVRE
VALLEYFIELD QC J6S 5L1SHIP TO:
EXPÉDIE À: ACIER CAMPI INC.
935 BOULEVARD DU HAVRE
VALLEYFIELD QC J6S 5L1Invoice Number
T243661

Ship# T593845

Description: 4130 CDS TUBING AMS T 6736 COND N; 85 KSI MIN
(.500 OD X .049 W) (.402 ID) X 17/24" R/L Line Total: 63.4 FT
HEAT: 748531 ITEM: 100046Specifications:
AMS T 6736 A
AMS 6371 J

MIL T 6736 COND N B

AMS 6360 L

CHEMICAL ANALYSIS

C	MN	P	S	SI	AL	CR	MO
0.314	0.54	0.007	0.003	0.25	0.034	0.87	0.17
NI	PB	CU	V	TI	SN		
0.0	0.001	0.1	0.003	0.003	0.01		

RCPT: R212595
MILL : PLYMOUTH TUBE

COUNTRY OF ORIGIN :

MECHANICAL PROPERTIES

DESCRIPTION	YLD STR KSI	ULT TEN KSI	%ELONG IN 02 IN	%RED IN AREA	HARDNESS RB
	107.568	111.963	20.0		100

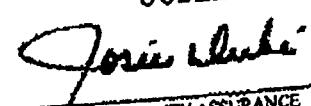
GRAIN SIZE : 8

The above data were transcribed from the manufacturer's Certificate of Test after verification for completeness and specification requirements of the information on the certificate. All test results remain on file subject to examination. Les informations ci-haut-mentionnées sont transcrites du certificat d'essai du manufacturier après vérification de l'état complet des spécifications inscrites sur le certificat. We hereby certify that the material covered by this report will meet the applicable requirements described herein, including any specification forming a part of this description. /Par les présentes, nous certifions que le matériel couvert par ce rapport respecte les spécifications décrites ci-haut.

The wilful recording of false, fictitious, or fraudulent statements in connection with test results may be punishable as a felony under federal statutes. /Les informations fausses, fictives ou frauduleuses en rapport avec le résultat des essais sont punissables en vertu des lois fédérales.

Material did not come in contact with mercury while in our possession. /Par les présentes, nous certifions que le matériel couvert par ce rapport rencontre les spécifications décrites ci-haut.

JOSEE DUBE


MANAGER QUALITY ASSURANCE
GÉRANT DE L'ASSURANCE QUALITÉ

CERTIFICAT D'ESSAIS

Page 02 of 02

Certification Date
18-DEC-2007CUSTOMER ORDER NUMBER
NUMÉRO DE COMMANDE DU CLIENT

36330-33

PART NUMBER/NUMÉRO DE PIÈCE

Invoice Number
T243661

Ship# T593845

SOLD TO: ACIER CAMPi INC.
VENDU À: 935 BLVD DU HAVRE
 VALLEYFIELD QC J6S 5L1

SHIP TO:
EXPÉDIÉ À:

ACIER CAMPi INC.
 935 BOULEVARD DU HAVRE
 VALLEYFIELD QC J6S 5L1

Description: 4130 CDS TUBING AMS T 6736 COND N; 85 KSI MIN
 .500 OD X .049 W (.402 ID) X 17/24' R/L Line Total: 63.4 FT
 HEAT: 748531 ITEM: 100046

MATERIAL IS FREE FROM MERCURY CONTAMINATION
 EDDY CURRENT/MAGNETIC TEST PERFORMED
 DECARB: OK
 AMS NO :2301
 SEVERITY :0.073
 FREQUENCY:0.107

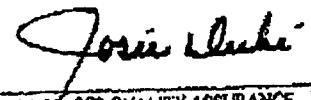
COMMENTS
 MELT SOURCE BENTELER

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